



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5633-1

Job Sheet 200846



Part No: D5633-1

Job Qty: 8 pcs *12 pcs*

Part Name: CAP



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/18/19

Job Tracking No:

Due Date: 10/19/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D5633 REV.A IPP REV:A 19.01.17 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	8 pcs		10/4/19	0.00	0.27	Bandsaw - 1		<i>DJP 18-10-19</i>
105	HAAS 4 Axis	8 pcs		10/4/19	1.00	5.97	HAAS - 1 - B4B		<i>DJP 19-10-19</i>
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
110	QC 2	8 pcs		10/4/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Container No: S223200



Part: D5633-1

Job No: 200846

Serial No/Batch: S223200

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/17/19

Plex 9/18/19 11:14 AM Dart.lajeunesse.marie

				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	DIP 17-10-19
				QC 2 - 69	
140 QC 8	8 pcs	10/4/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	D.a 19-10-22
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
150 Packaging 3-1 - Stock - B4B	8 pcs	10/4/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	✓ ST 12g
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	

OCT 24 2019

12 Oscar

				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	8 pcs ✓	10/4/19	0.00 0.00	QC 21 - SA - 21 ✓	ST 174
				QC 21 - SA - 70	OCT 24 2019

Part Op 100 - CUT BLANK AT 10.700"

Descriptions: 105 - 1-Machine as per Folio FC779 and Dwg D5633 DWG REV. A FOLIO REV. AA 2-Deburr

110 - QC2- Inspect parts off machine FAI/FAIB

140 - QC8- Inspect parts - second check

150 - Identify as per dwg & Stock Location: ***STOCK IN SKIDTUBE CELL*** LOCATION : LG001

160 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X4.500	6061-T6 Bar 1.25 X 4.50	7.1360 ft (.892 ea)	100-Bandsaw - 1	5166893 X6 5221811 X6

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.250X4.500	7	8	0

Part Specifications	
Specifications could not be found.	

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DART AEROSPACE LTD		Work Order:	200846
Description: Tow Step		Part Number:	D5633-1
Inspection Dwg: D5633	Rev: A	Page 1 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.50	(±).030	10.50	✓		Dev.	CNC 02
3.75	(±).030	3.75	✓		Dev.	
2.63	(±).030	2.62	✓		Dev.	
2.50	(±).030	2.515	✓		Dev.	
0.130	(±).030	0.130	✓		Dev.	
R.0.38	(±).030	R.0.38	✓		R.G.	
0.65	(±).030	0.65	✓		Dev.	Calculated
0.375	(±).010	0.375	✓		Dev.	
1.875	(±).030	1.875	✓		Dev.	
0.25	(±).030	0.255	✓		Dev.	
0.50	(±).030	0.50	✓		Dev.	
0.25	(±).030	0.24	✓		Dev.	
0.25	(±).030	0.255	✓		Dev.	
0.50	(±).030	0.50	✓		Dev.	
1.00	(±).030	1.005	✓		D.G.	
0.375	(±).010	0.376	✓		Dev.	
0.03x45°	(±).03 x (±).5°	0.03x45°	✓		Dev.	
R.0.13	(±).030	R.0.123	✓		R.G.	
0.38	(±).030	0.37	✓		Dev.	
0.188	(±).010	0.186	✓		Dev.	
0.06	(±).030	0.068	✓		Dev.	
1.05	(±).030	1.05	✓		Dev.	
0.45	(±).030	0.45	✓		Dev.	
R.0.25	(±).030	R.0.25	✓		R.G.	
1.80	(±).030	1.80	✓		Dev.	
0.750	(±).010	0.750	✓		Dev.	
0.125	(±).010	0.125	✓		Dev.	
2.563	(±).010	2.565	✓		H.G.	
1.00	(±).030	1.004	✓		Dev.	

Measured by: 52	Checked by: Dr	QC Inspector:
Date: 19/10/18	Date: 19-10-22	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS				MRB (QS1042)																																																									
Job: _____ Part No. _____	Rework Scrap Use-as-is	Skid-tube Machining Large Fab	Cross tube Small Fab Finishing	Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging	Engineering Water Jet Supplier Quality																																																										
Date: _____	Sequence #: _____	QTY Affected: _____				Completed By																																																									
Description Work Order Deviation		Disposition																																																													
Root Cause <table border="1"><tr><td>Operator</td><td></td></tr><tr><td>Manufacturing Process</td><td></td></tr><tr><td>Equip/Tooling</td><td></td></tr><tr><td>Handling/Preservation</td><td></td></tr><tr><td>Material</td><td></td></tr><tr><td>Product Improvement</td><td></td></tr><tr><td>Process Improvement</td><td></td></tr><tr><td>Human Factors</td><td></td></tr></table>		Operator		Manufacturing Process		Equip/Tooling		Handling/Preservation		Material		Product Improvement		Process Improvement		Human Factors		FAULT CATEGORY <table border="1"><tr><td>Contamination</td><td></td><td>Power Loss/Surge</td><td></td><td>Positioned Wrong</td><td></td></tr><tr><td>Misaligned/off center</td><td></td><td>Folio/Program</td><td></td><td>Outside Tolerance</td><td></td></tr><tr><td>BOM/Route</td><td></td><td>Grain Direction</td><td></td><td>Drawing</td><td></td></tr><tr><td>Broken/Damage/Defect</td><td></td><td>Weld</td><td></td><td>Finish</td><td></td></tr><tr><td>Incomplete/Unclear Instructions</td><td></td><td>Wrong Stock Pulled</td><td></td><td>Part Lost/Missing</td><td></td></tr><tr><td>Drill Holes</td><td></td><td>Out of Sequence</td><td></td><td>Misread</td><td></td></tr><tr><td>Fit/Function</td><td></td><td>Off-set/Set-up</td><td></td><td></td><td></td></tr></table>				Contamination		Power Loss/Surge		Positioned Wrong		Misaligned/off center		Folio/Program		Outside Tolerance		BOM/Route		Grain Direction		Drawing		Broken/Damage/Defect		Weld		Finish		Incomplete/Unclear Instructions		Wrong Stock Pulled		Part Lost/Missing		Drill Holes		Out of Sequence		Misread		Fit/Function		Off-set/Set-up			
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